

Work Order ID 81663

81663

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March-16-12 1:54:43 PM

Item ID: DSI 9396-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Crosstube Support Change

Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/14

Tooling:

Date:

Run Start *NR1*


QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9396	Rev B	xSP	105 -	Pick Kit		SP	12-04-23		
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels as per PPP DSI 9396 CHG001			S. 12/4/24				HJ for MLJ 12-4-23	(2)
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control				S. 12/4/24				(12)	
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9396								
	Location: <u>20</u> PPP Rev: <u>DRAFT</u>								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81663***81663***

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Item ID: DSI 9396-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Crosstube Support Change

Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/4/25
12-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 81663

81663

Parent Item: DSI 9396-011

DSI 9396-011

Parent Item Name: Fwd Crosstube Support Change

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-12-17 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3595-063-450

Manufactured

No

110

Each

134.1095

4

8

**

D3595-063-450

RUBBER CUSHION

Location

Loc Qty

Loc Code

LG051

88

80161

88

MAT052

46.109474

67353

2

68893

6

70113

0.56

71354

0.2

74113

0.349474

75597

1

77678

36

MS21920-25

Purchased

No

110

Each

165.0000

4

8

**

MS21920-25

Clamp(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG050

165

116264

2

117998

4

118142

4

119339

2

119746

2

120054

1

120475

50

120920

100

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-594 Rev. C (AND EARLIER) AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-594 Rev. 2 (AND EARLIER)
REF. CANADIAN STC: SH03-6
REF. FAA STC: SR01742NY

For D205-596-101/-103 Crosstubes (ref. 39" Landing Gear) or D205-596-105/-107 Crosstubes (ref. 31" Landing Gear) at CHG 002 or later, the D2856-600-851/-1009 Abrasion Strips have been removed, the MS21920-25 Clamp replaces the MS21920-24 Clamps, the D2893-1 and D2940-1 Supports have been bonded onto the crosstubes using Magnobond 6398 and D3595-063-450/-530 Rubber Cushions have been installed underneath the MS21920-25/-28 Clamps. Amend Parts List of IIN-D205-594 Section 5 and ICA-D205-594 Section 32.8 as follows:

Remove:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
2		2		D2856-600-851	ABRASION STRIP
	2		2	D2856-600-1009	ABRASION STRIP
4		4		MS21920-24	CLAMPS

Add:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
4		4		D3595-063-450	RUBBER CUSHION
	4		4	D3595-063-530	RUBBER CUSHION
4		4		MS21920-25	CLAMP

To prevent the supports from shifting on D205-596-101/-103/-105/-107 Crosstubes at CHG 001, the D2893-1 or D2940-1 Supports should be removed and re-installed as follows:

- Follow section 32.1 of ICA-D205-594 for the removal of the crosstubes from the helicopter.
 - Remove the MS21920-24/-28 Clamps that fasten the D2893-1 and D2940-1 Supports from the crosstubes per Section 32.3 of ICA-D205-594.
 - Remove the D2856-600-851/-1009 Abrasion Strips from the crosstube per section 32.5 of ICA-D205-594.
 - Inspect the crosstube surface underneath the supports for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.3 of the 300 hour inspection.
 - Inspect the supports for corrosion and mechanical damage per items 5.3.4 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.4 of the 300 hour inspection.
 - Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
 - Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2893-1 or D2940-1 Supports and re-install the Supports on the crosstube as shown in Figure 1. Install a D3595-063-450/-530 Rubber Cushion on each MS21920-25/-28 Clamp. Position and secure the D2893-1 or D2940-1 Supports on the crosstube using MS21920-25/-28 Clamps. Torque clamps to 80-100 in-lb. Let the D205-596-101/-103/-105/-107 Crosstube Assembly cure before re-installing the crosstube on the aircraft.
- Note:** It is acceptable to substitute the MS21920-25/-28 with longer or shorter clamps to accommodate varying diameters. Ensure there is a minimum of 1.5 threads in safety on the nut.
- Re-install the D205-596-101/-103/-105/-107 crosstube per section 32.2 of ICA-D205-594.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.12.04
CERT. NO.: SH03-6
ISSUE NO.: 3

B	REPLACE MS21920-24 WITH MS21920-25 ON -101/-105; ADDED EXTRA NOTE TO INSTALLATION PROCEDURE (STEP 7)	MB	07.12.04
A	NEW ISSUE	MB	07.11.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9396	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
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Dart Aerospace Ltd

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For customers who would like to upgrade their D205-596-101/-103/-105/-107 Crosstubes from CHG 001 to CHG 002, the following kits can be obtained from Dart:

DSI 9396-XXX PARTS LIST

QTY -011	QTY -013	Part Number	Description
X		DSI 9396-011	FWD CROSSTUBE SUPPORT CHANGE (D205-596-101/-105 FWD CROSSTUBE)
	X	DSI 9396-013	AFT CROSSTUBE SUPPORT CHANGE (D205-596-103/-107 AFT CROSSTUBE)
4		D3595-063-450	RUBBER CUSHION
4		MS21920-25	CLAMP
	4	D3595-063-530	RUBBER CUSHION
	4	MS21920-28	CLAMP

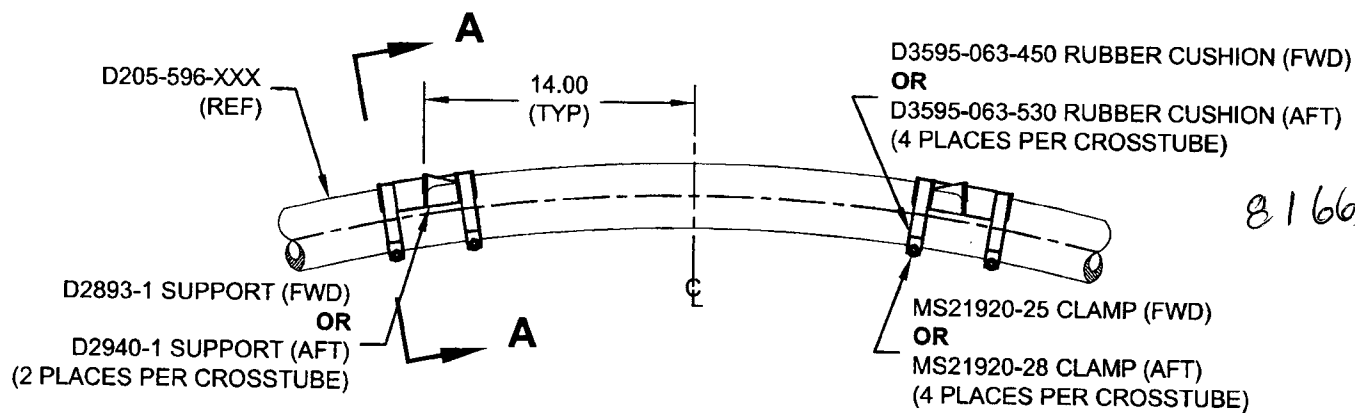
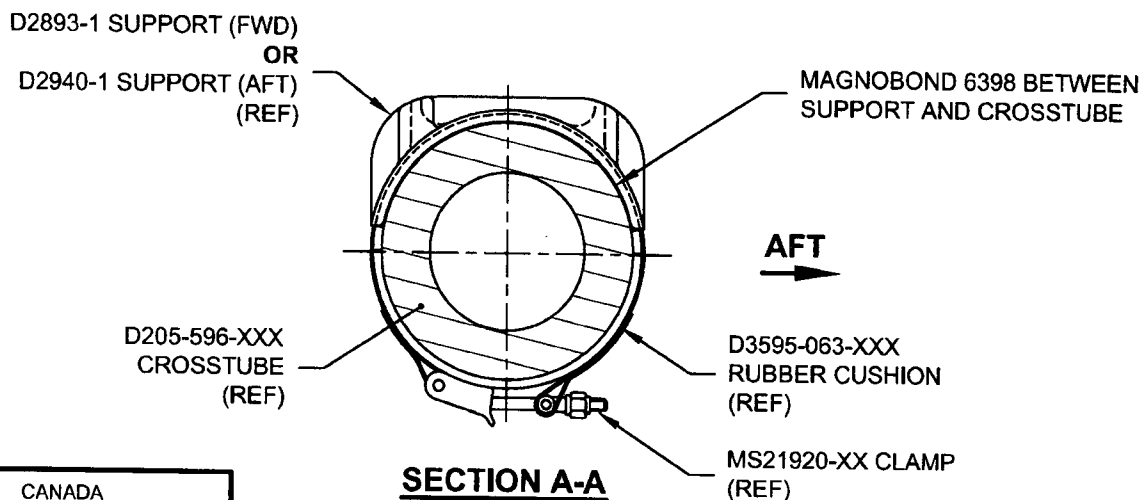


FIGURE 1: INSTALLATION OF SUPPORT ON CROSSTUBE



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.12.04
CERT. NO.: SH03-6
ISSUE NO.: 3

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	E	DSI 9396	SHEET 2 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CH	CROSSTUBE SUPPORT CHANGE	NTS
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